

**Work Order ID 77512**

December-12-11 8:30:08 AM

**\*77512\***

Page 1

Item ID: D3852-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly

Start Date: 12/12/2011 Start Qty: 2.00

Required Date: 16/12/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

\*2\*  
\*2\* (4)

Approvals: Process Plan: M.L.J Date: 11/12/12 Tooling:

Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3852	Rev A
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100

0.00

**\*1000\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 4115778

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

12.01.23 4x12.01.19 (x4) Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 77512**

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**\*77512\***

Page 2

Item ID: D3852-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Rib Assembly

Stop **\*NS2\***

Start Date: 12/12/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 16/12/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC10- Inspect visual per QS1004- ground welds

0.00

**\*130\***

QC

Memo

0.00

8/12/11/24

Quality Control

140 QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

8/12/11/24

Quality Control

(40)  
-UC1

150 Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*150\***

Packaging

Memo

0.00

Bodert cell

Packaging

12.01.23 YK

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 77512**

December-12-11 8:30:08 AM

**\*77512\***

Page 3

Item ID: D3852-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Rib Assembly  
Start Date: 12/12/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 16/12/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/11/24

12-01-24  
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-12-11 8:30:14 AM

Page 1

Work Order ID: 77512

**\*77512\***

Parent Item: D3852-041

**\*D3852-041\***

Parent Item Name: Rib Assembly

Start Date: 12/12/2011

Required Date: 16/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	3.0000	0.18	0.378947			

**\*D3166-3\***

Basket-Hoop

\*\*

*Ac 12.01.19*

Location

Loc Qty

Loc Code

WA007

3

73627

3

D3759-1

Manufactured

No

100

Each

297.0000

1

2

**\*D3759-1\***

Bushing

\*\*

*0.757894*

*12.01.23*

Location

Loc Qty

Loc Code

WA005

297

66489

2

72316

14

74443

80

74783

201

*4x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

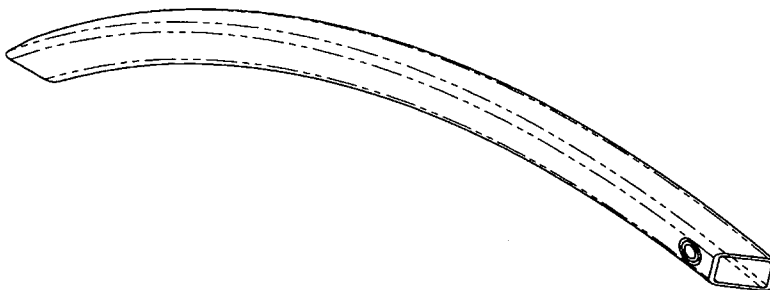


8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



**D3852-041 RIB ASSEMBLY**



**D3852-042 RIB ASSEMBLY**

SHOWN COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO A REWORKMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 37512 11/12/12

M.C.U

RELEASE  
 08/11/18 MP

- NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.83 lbs EACH  
 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA  
 DRAWING NO. **D3852**  
 TITLE **RIB ASSEMBLY**  
 REV. A  
 SHEET 1 OF 3  
 SCALE  
 NTS

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

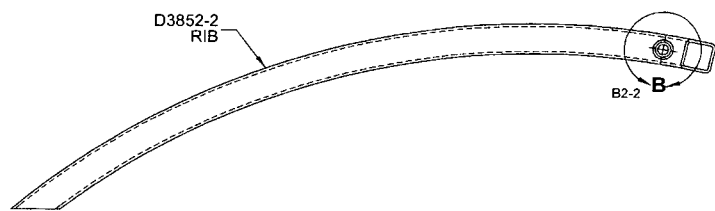
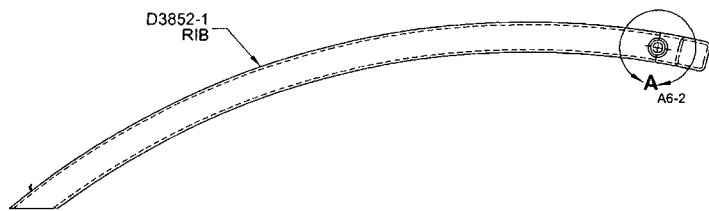
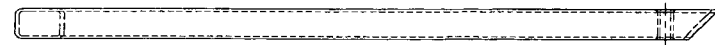
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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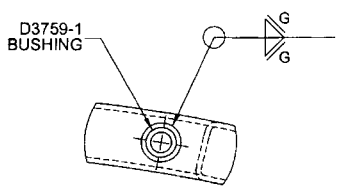
**NOTE:** Date & initial all entries

77512

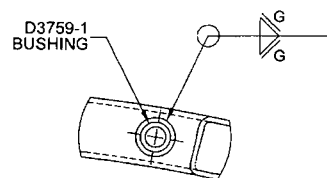


**D3852-041 RIB ASSEMBLY**

**D3852-042 RIB ASSEMBLY**



**DETAIL A**  
SCALE 2X C5-2



**DETAIL B**  
SCALE 2X C2-2

**RELEASED**  
08/11/15

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO. <b>D3852</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
DATE	08.11.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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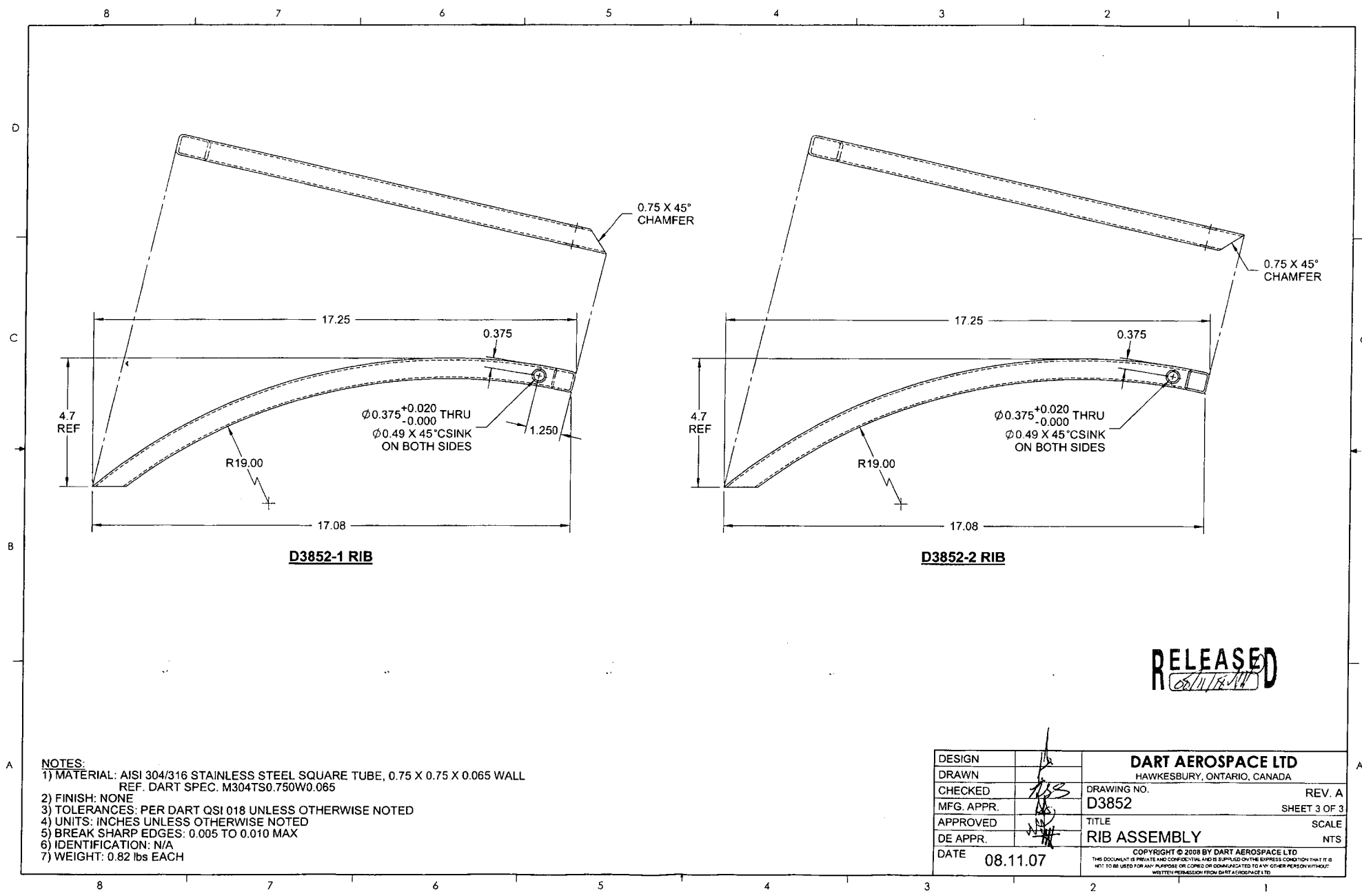
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**NOTE:** Date & initial all entries

77572



**D3852-1 RIB**

**D3852-2 RIB**

**RELEASED**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.82 lbs EACH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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